

Work Order ID 69589-2 *Split*

Thursday, May 12, 2011 2:38:30 PM

Page 1

Item ID: D3372-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/20/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *MF*

Date: 11-05-12 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
Identify as D3372-3

EP 11/05/24

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 11/05/24

120

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as
D3369-5

SB 11/05/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69589

Thursday, May 12, 2011 2:38:30 PM

Page 2

Item ID: D3372-041

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

1-Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads

SN 11/05/24

Qty Part Number Description Batch

A/R N/A Locktite 262 H13436

Identify as D3372-053

2-Assemble D3372-051 as per Dwg

→ EF 11/05/26

(2)

140



Large Fab

Large Fab

0.00

Memo

0.00

Tack weld lock shaft as per Dwg D3372

A/R SS Rod Batch 115928

11-05-24

3

φ

Work Order ID 69589

Thursday, May 12, 2011 2:38:30 PM

Page 3

Item ID: D3372-041

Accept

Revision ID:

Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00

Required Date: 5/20/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 11.05.24

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/27

(72)

170

Identify as per dwg & Stock Location: 493

0.00



Packaging

Memo

0.00

Packaging

11/5/27 SP3

Work Order ID 69589

Thursday, May 12, 2011 2:38:30 PM

Page 4

Item ID: D3372-041

Accept

Revision ID:

Item Name: Collective Lock Assembly

Start Date: 5/13/2011 Start Qty: 1.00

Required Date: 5/20/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/30
UMF
11-05-27

Picklist Print

Thursday, May 12, 2011 2:38:28 PM

Page 1

Work Order ID: 69589

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
IPP Rev:B Added Key ID 06.03.21 EC
added D3384-043 DD 10.05.13 verified :EC IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC

Purchased

No

100

Each

3,387.000

2

2

SN 1165/24

SS Flat Washer 5/16 FW516S1

Location

Loc Qty

Loc Code

st376

2000

117332

2000

ST377

1387

115072

100

115174

65

116643

1222

8

AN5-42A

Purchased

No

100

Each

26.0000

1

1

SN 1165/24

Bolt

Location

Loc Qty

Loc Code

ST341

26

108442

26

4

SN 1165/24

AN960-416

NAS1149F0463P

Purchased

No

100

Each

0.0000

2

2

M 116702

8

SN 1165/24

Washer

D2728-7

Manufactured

No

100

Each

0.0000

0

0

SN 1165/24

Dart Logo label

D3372-1

Manufactured

No

100

Each

0.0000

1

1

B 69 571

Main Body

Picklist Print

Thursday, May 12, 2011 2:38:28 PM

Page 2

Work Order ID: 69589



Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 5/13/2011

Required Date: 5/20/2011

Start Qty: 1.00

Required Qty: 1.00

D3372-5

 Cam Lock Shaft

Manufactured No

100 Each 5.0000



SS 11/05/24

Location Loc Qty Loc Code

ST048 5
 59557 5

4

SS 11/05/24

D3372-7

 Slider Body

Manufactured No

100 Each 1.0000



Location Loc Qty Loc Code

ST485 1
 58439 1

B 69633

3

SS 11/05/24

D3373-1

 Cam Lock

Manufactured No

100 Each 20.0000



Location Loc Qty Loc Code

ST049 20
 58463 20

3

SS 11/05/24

D3384-043

 Cyclic Sock Assembly

Manufactured No

100 Each 0.0000



SS 11/05/24

HX-81

 1/4"-20 SHCS 3/8" long

Purchased No

100 Each 33.0000



Location Loc Qty Loc Code

ST390 33
 114383 33

4

SS 11/05/24

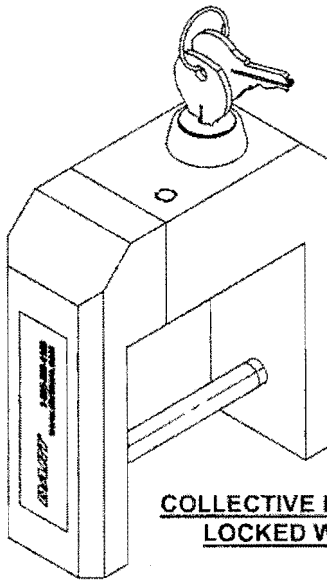
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Shop Packet Print

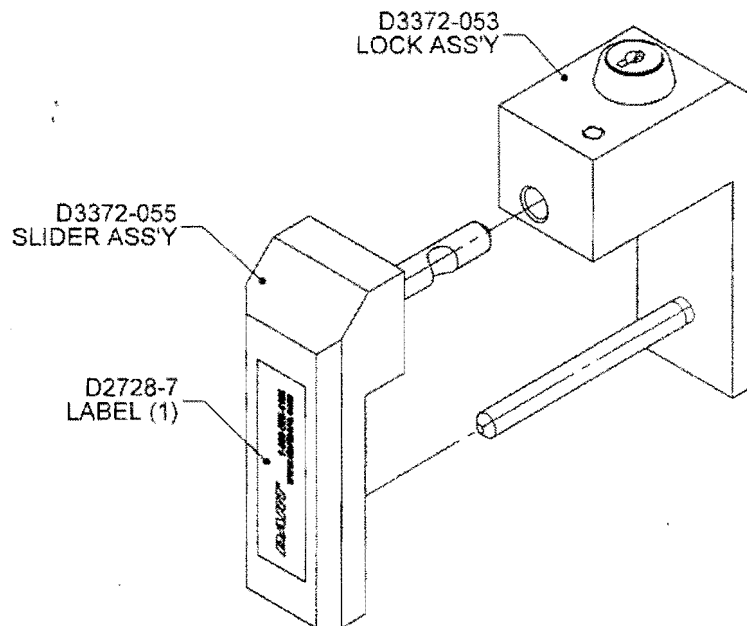
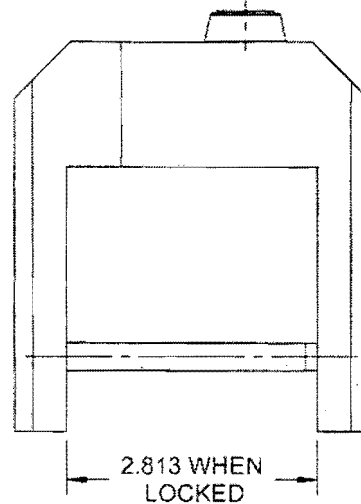
Page 2



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



RELEASED
05/04/28

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

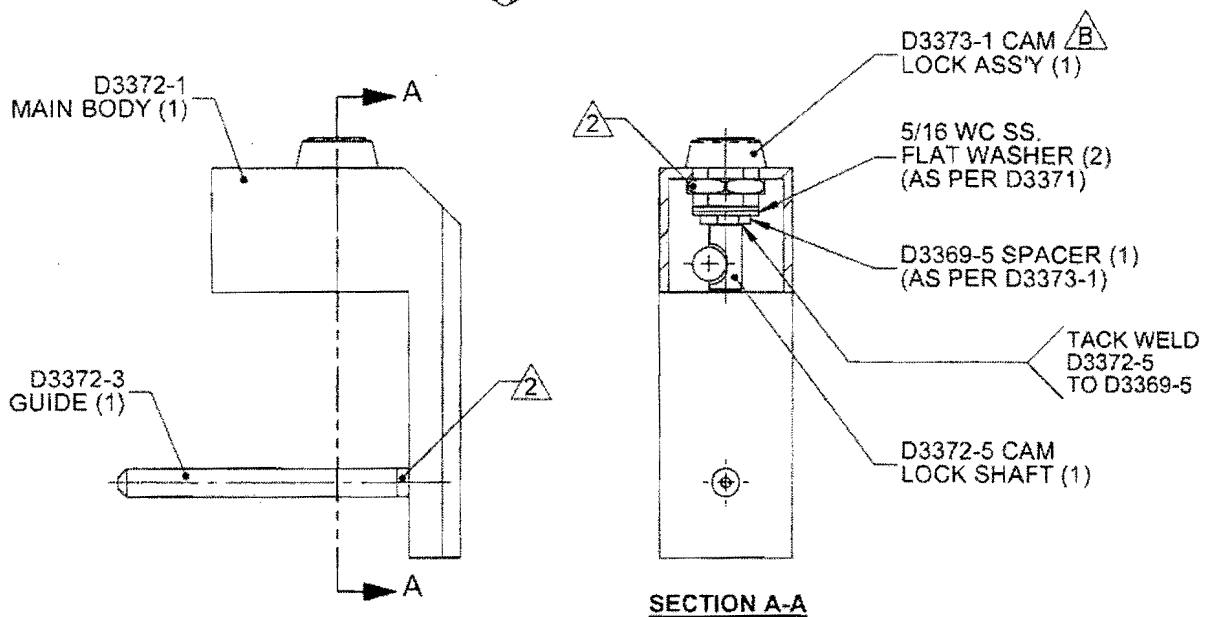
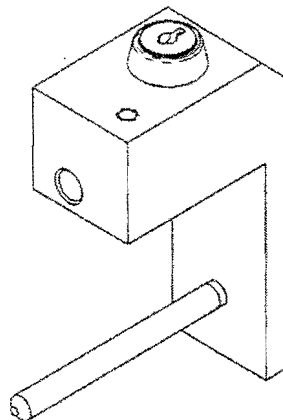
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DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3372	REV. B SHEET 2 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

RELEASED
20/04/22



D3372-053 LOCK ASS'Y

NOTES:

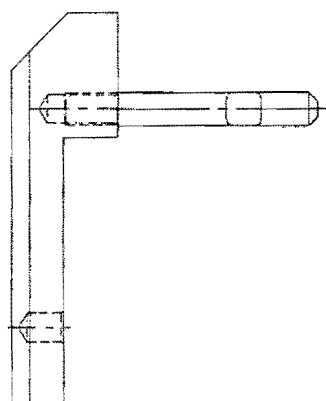
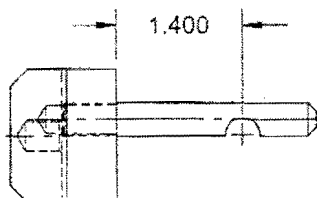
- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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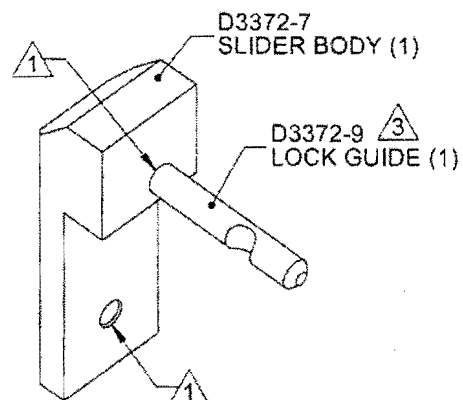
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



RELEASED
27/04/23



D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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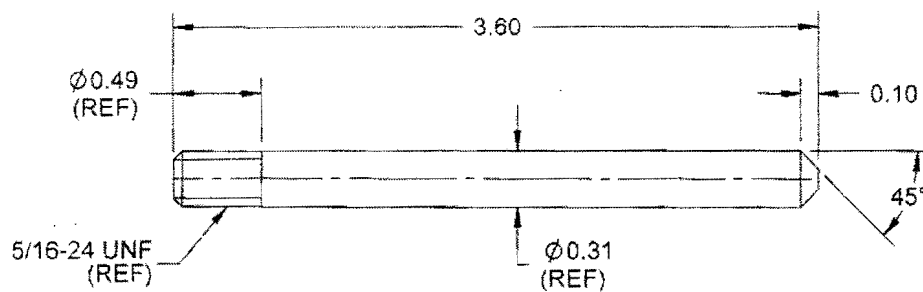




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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 5 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]
05/04/23



D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

